ate:

Tuesday, 28/04/2009 12:38:16 PM

User:

Julie Dawson

Process Sheet

Customer

Prsht Rev.

First Issue

Written By

Comment

Previous Run

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number**

: 47563A

P.O. Number

: 10731

This Issue

: 28/04/2009

: NC

: // : 45886A Type

S.O. No. :

Part Number

Drawing Name

: D23243

: STOP

Drawing Number

D2324 REV. C

Project Number **Drawing Revision**

: N/A : C

Material

Due Date

: 01/05/2009

Qty:

20 Um:

Each

Checked & Approved By

: Est:

: SMALL /MED FAB

Reformat; Incorporated D2324-3 & D2324-5 K 03.02.28

J/RF

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

6061-T6 Bar .750 x .750



Comment: Qty.:

0.5565 f(s)/Unit

Total: 11.1300 f(s) + 1 F+ Scrap

6061-T6 Bar 0.75" x 0.75"

Material: 6061-T6/6511 (QQ-A-200/8) or (QQ-A-225/8) or 5052-H34 (QQ-A-225/7) or (QQ-A-250/8)

(M6061T6B0.750x00.750)

Batch: <u>M/03877</u>

2.0

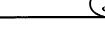
BAND SAW

BAND SAW



Comment: BAND SAW

Cut blanks: (0.75" x 0.75") x 5.75" Long Bar



3.0

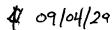
HAAS1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio D2324-3 and Dwg D2324

2- Deburr and Tumble to remove sharp edges Identify as D2324-3





4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

\$ 09/04/29





5.0

QC8

SECOND CHECK





Comment: SECOND CHECK



W/O:	•	· · · · · · · · · · · · · · · · · · ·	WO	RK ORDER CHANG	ES		_				
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
							·				
Part No	:	PAR #:	Fault Categ	jory:	_ NCR:	Yes N	lo DQ	A :	Date:		
Reso		solution:	Disposition:			QA: N/C Closed:			Date:		
NCR:			WORK ORDE	R NON-CONFORMA	ANCE	(NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section Initial Action Description			Verific		cation Approval		Approval	
		Section A	Chief Eng	Chief Eng		Date	Secti	on C	Chief Eng	QC Inspector	
				Y							

Tuesday, 28/04/2009 12:38:16 PM Date: Julie Dawson User: **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: STOP Job Number: 47563A Part Number: D23243 Job Number: Seq. #: **Machine Or Operation:** Description: 6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 INSPECT POWDER COAT/CHEM/CAL CONVERSIO 7.0 QC3 Comment: INSPECT ALODINE 8.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock FINAL INSPECTION/W/O RELEASE 9.0 Comment: FINAL IN PECTION/W/O RELEASE Job Completion

W/O:				WORK ORDER	CHANGES					
DATE	STEP		PRO	CEDURE CHANGE	By	Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			•							
Part No	:		PAR #:	Fault Category:	NCR:	Yes	No DQ	A:	Date: _	
Resolution:			Disposition:	QA: N	QA: N/C Closed:				Date:	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
	T	Description of NC		Corrective Action Section B		Verification	A	Approval QC Inspector			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng				
				- 1-							
	1 1										

DART AEROSPACE LTD	Work Order:	1475BH
Description: Strut	Part Number:	D2324-3
Inspection Dwg: D2324 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First	Article	Prototype
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Drawing	Talamanaa	Actual	A +	Daisat	Method of	Comments
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
Ø0.257	+/-0.010	,259	*			
Ø0.191	+/-0.010	,193				
0.750	+/-0.010	,751				
0.375	+/-0.010	,373				
1.875	+/-0.010	1.873				
5.250	+/-0.010	5.249				
5.625	+/-0.010	5.623				
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					. ,	

Measured by:	Audited by:	<u>ا</u> ل	Prototype Approval:	N/A
Date: 05/04/2	9 Date:	09/04/79	Date:	N/A

Rev	Date	Change		Revised by	Approved
Α	04.06.10	New Issue	P/O D2324-1	KJ/JLM ,	
В	06.03.08	Dwg Rev changed		KJ/JLM A	

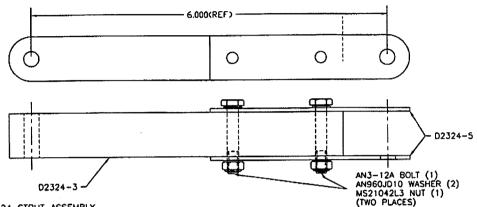
	•											
W/O:		WORK ORDER CHANGES										
DATE	STEP	PR	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
				•								
Part No	:	PAR #:	Fault Cate	gory:	NCR	: Yes I	No DQ	A:	Date:			
Resolution: Disposition:				າ:	QA: N/C Closed: Date:							
NCR:		·	WORK ORDI	R NON-CONFORM	MANCE	(NCR				.,,,,,,		
DATE	CTED	Description of NC	Corrective Action Section				Verific	ation	Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	1	Sign & Date	Secti		Chief Eng	QC Inspector		
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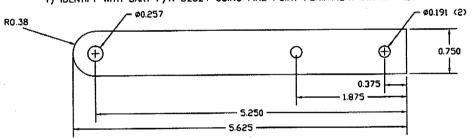
DESIGN DRAWN BY DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA **B WILLIAMS** PH REV. C CHECKED APPROVED DRAWING NO. D2324 SHEET 1 OF 1 SCALE TITLE DATE 04,12,14 **STRUT** 94.11.08 NEW ISSUE Α 96.05.07 UPDATE MATERIALS В

RELEASED 04.12.16

UPDATE NOTES C 04.12.14



D2324 STRUT ASSEMBLY 1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER



D2324-3

6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75 1) MATERIAL:

(REF DART SPEC. M6061T680.750X00.750)

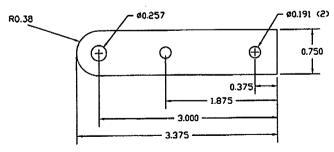
ACID ETCH AND ALODINE PER DART QSI 005 4.1 2) FINISH:

POWDERCOAT WHITE (4.3.5.1) PER DART QSI QQ5 4.3

3) BREAK ALL SHARP EDGES 0.005 TO 0.015

4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



02324 - 5

AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK) 1) MATERIAL: (REF DART SPEC. M304S16GA)

POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3 2) FINISH:

3) BREAK ALL SHARP EDGES 0.005 TO 0.015

4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED

SHOP COPY **RETURN TO ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER

W/O:			WORK ORDER CHANGES									
DATE STEP		PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
		1										
						100000000000000000000000000000000000000						
Part No:		PAR #:	Fault Cate	gory:	NCR: Yes No DQA: Date							
Resolution:			Dispositio	QA: N/C C								
NCR:		,	WORK ORD	ER NON-CONFORM	ANCE (NC	₹)						
DATE	STEP	Description of NC			Section B		ation	Approval	Approval			
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti	on C	Chief Eng	QC Inspector			
								,				